

Work Order ID 114009-1

March-07-14 12:58:45 PM

114009

Page 1

Item ID: D4822-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Upper Right Deflector

Stop *NS2*

Start Date: 2/28/14 Start Qty: 11.00

11

Cust Item ID:

Required Date: 3/07/14 Req'd Qty: 11.00

11

Customer:

Reference: REWORK -ECN14-516

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4822

C

101

Outsource process - Machining

0.00

101

Outsource5

Memo

0.00

Outsource process - Machining

PULL FROM STK:

1 X D4822-2 B106971

10 X D4822-2 B109788

SEND TO WEJAY FOR REWORK PER REV. C

PO 23205

103

Receive & Inspect for Damage & Mat'l Certs

0.00

103

Packaging

Memo

0.00

Packaging

105

QC5- Inspect part completeness to step on W/O

0.00

105

QC

Memo

0.00

Quality Control

CX 14/03/03 11

14/3/1 (1)

SMP
14/3/0

1

Work Order ID 114009

March-07-14 12:58:45 PM

114009

Page 2

Item ID: D4822-2 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Right Deflector
 Start Date: 2/28/14 Start Qty: 11.00 *11* Cust Item ID:
 Required Date: 3/07/14 Req'd Qty: 11.00 *11* Customer:
 Reference: REWORK -ECN14-516

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
116		0.00							
116						1	0	0	AS
HandFinish	Memo	0.00							14-3-10
Hand Finishing	touch up holes with primer B <u>127401</u>								
121	QC14- Inspect Spray Paint	0.00							
121									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>SK</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	re-identify using new B/N								

DAS
27
9-89
14/3/10

14-03-10

Work Order ID 114009

114009

Page 3

March-07-14 12:58:45 PM

Item ID: D4822-2

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Right Deflector

Start Date: 2/28/14

Start Qty: 11.00

11

Cust Item ID:

Required Date: 3/07/14

Req'd Qty: 11.00

11

Customer:

Reference: REWORK -ECN14-516

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MW 14-03-11

U14-03-10

Picklist Print

March-07-14 12:58:44 PM

Page 1

Work Order ID: 114009

114009

Parent Item: D4822-2

D4822-2

Parent Item Name: Upper Right Deflector

Start Date: 2/28/14

Required Date: 3/07/14

Start Qty: 11.00

Required Qty: 11.00

Comments: IPP REV:A NEW ISSUE 13-04-19 JLM VERIFIED BY:DD

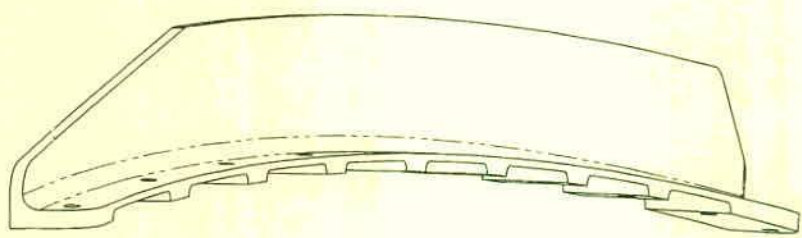
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4822-2		Manufactured	No				Each	0.0000		11			
D4822-2									**				
Upper Right Deflector													

1-4/3/14 (1)
1x D4822-2 B106971
10 x D4822-2 B109788 140228

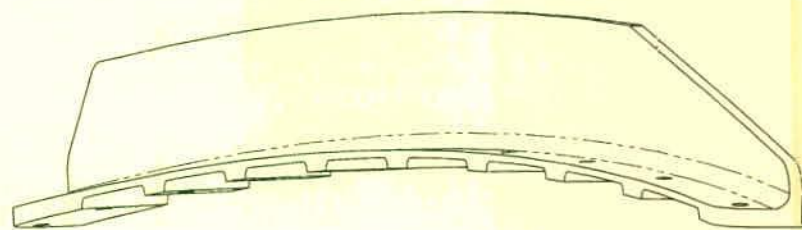
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D4822-1 UPPER DEFLECTOR LH



D4822-2 UPPER DEFLECTOR RH

also 11409

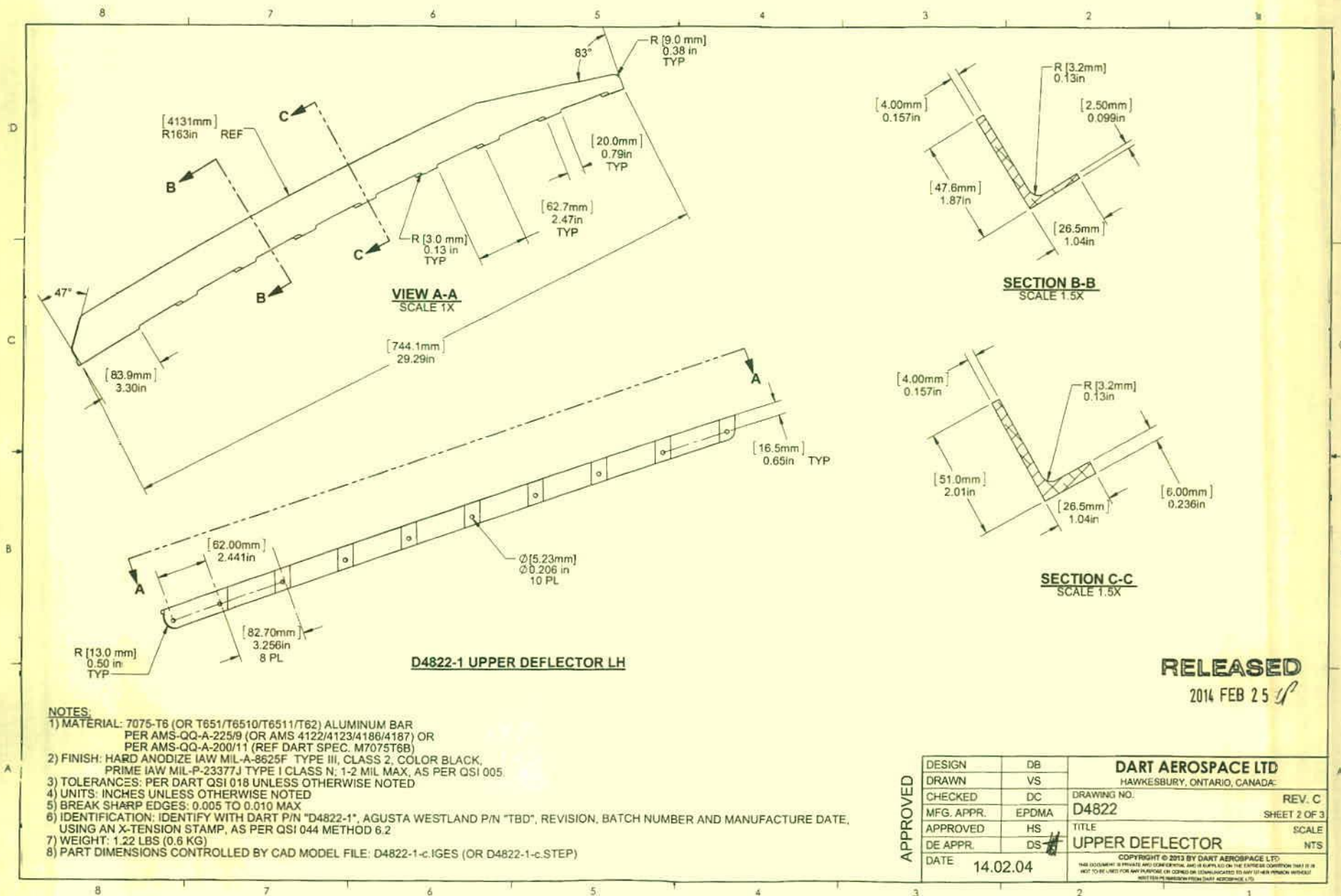
RELEASED

2014 FEB 25 47
ECW 4-516

C	DRAWING REVISED TO NEW CUSTOMER CAD DATA. RIVET HOLES ADDED	DB	14.02.04
B	CORRECTED WEIGHT	DW	13.09.24
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTS
DATE	14.02.04	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS UNCLASSIFIED AND IS RELEASED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

APPROVED

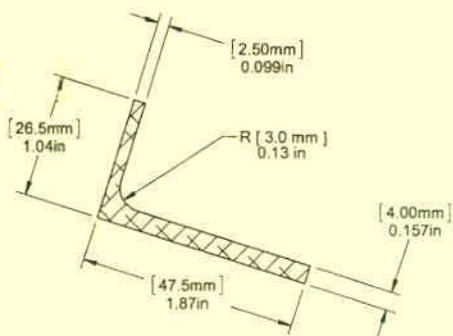
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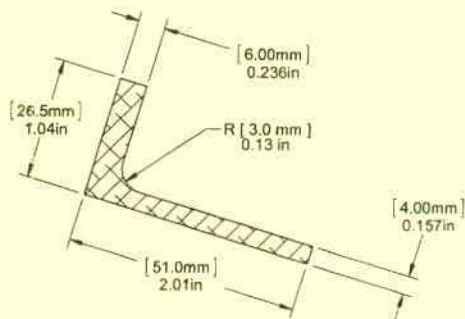
RELEASED
2014 FEB 25

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTS
DATE	14.02.04	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

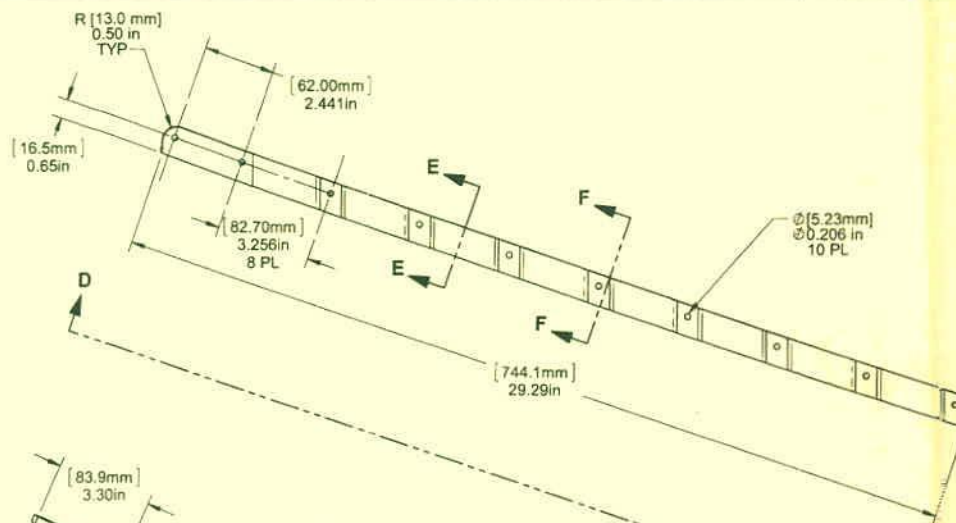
8 7 6 5 4 3 2 1



SECTION E-E
SCALE 2X



SECTION F-F
SCALE 2X



VIEW D-D
SCALE 1X

D4822-2 UPPER DEFLECTOR RH

RELEASED

2014 FEB 25

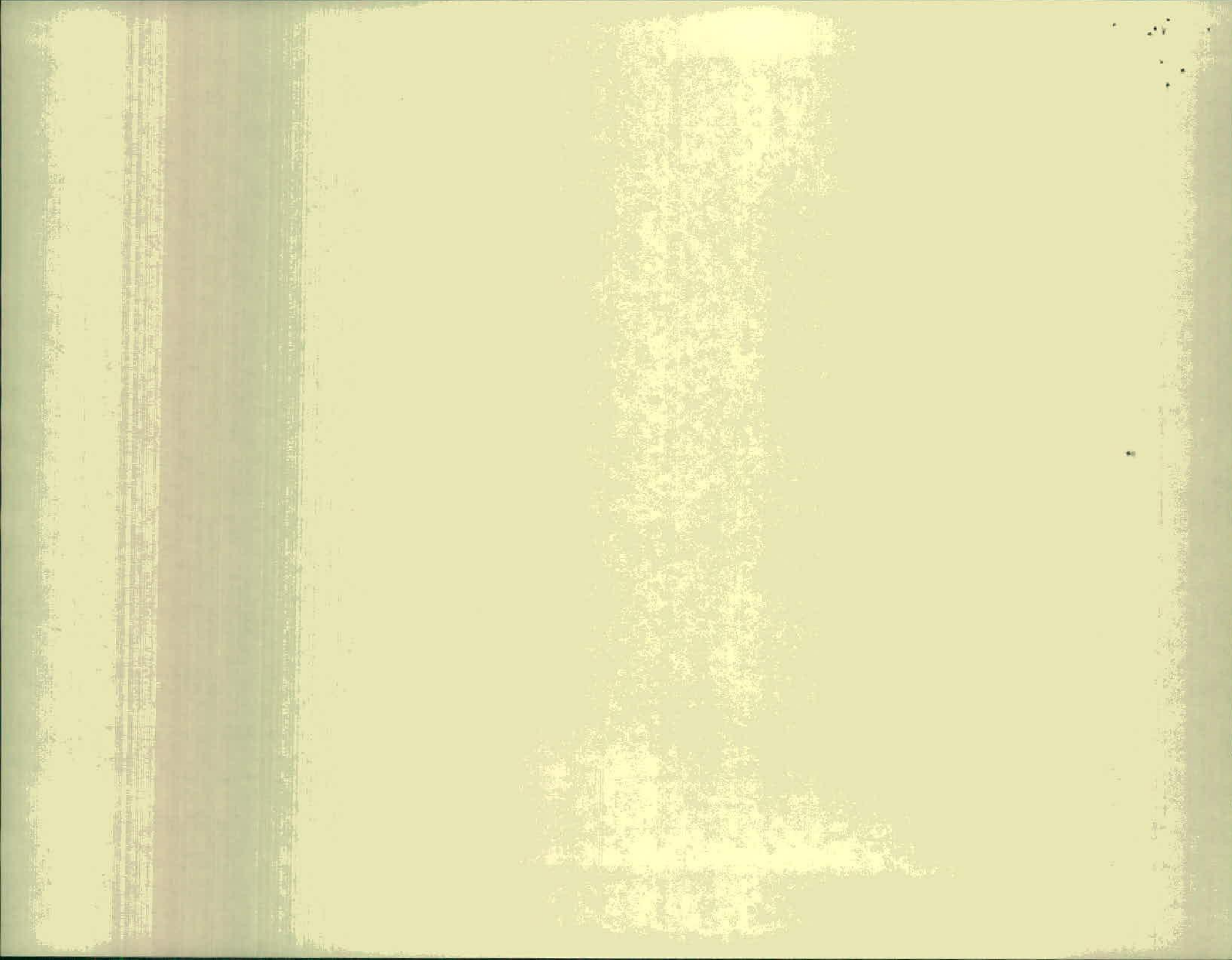
NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC. M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625F TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4822-2", AGUSTA WESTLAND P/N "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE,
USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 1.22 LBS (0.6 KG)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4822-2-c.IGES (D4822-2-c.STEP)

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTS
DATE	14.02.04	COPYRIGHT © 2015 BY DART AEROSPACE LTD.	
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8 7 6 5 4 3 2 1



Linda Lacelle

From: David Shepherd
Sent: March-07-14 10:28 AM
To: Pablo Bravo; Linda Lacelle
Cc: Mike Petsche; Bill Beckett
Subject: RE: 169 CCS Wiper Deflectors

Yes ... I'm good with that ... Didn't realize that the parts were already anodized and primed.

Regards,
David

From: Pablo Bravo
Sent: March-07-14 8:26 AM
To: Linda Lacelle
Cc: David Shepherd; Mike Petsche; Bill Beckett
Subject: Re: 169 CCS Wiper Deflectors

I would think that since it's a trial fit we would just need to apply touch up primer to the holes and maybe an Alodine solution before primer.

Shep, what say you?

On Mar 7, 2014, at 7:21 AM, "Linda Lacelle" <llacelle@dartaero.com> wrote:

Sorry, maybe I'm wasn't clear. They are already anodized and primed, but they have been drilled to the latest revision, so the holes are not anodized and primed, since this is just a trial fit, I was just wondering if they needed to be touched up anodize/prime..

Thx
L

From: David Shepherd
Sent: March-07-14 10:10 AM
To: Linda Lacelle; Mike Petsche
Cc: Pablo Bravo; Bill Beckett
Subject: RE: 169 CCS Wiper Deflectors

I would say "YES" ... let's anodize and paint them.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23205

Purchase Order Date 3/3/2014

PO Print Date 3/3/2014

Page Number 2 of 3

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-384-1662

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

COD

Currency

CAD

FOB

Destination-Collect

3	114008	D4822-1 MOD UPPER DEFLECTOR	3/28/2014	10.00	\$96.00	\$960.00
			Yes 3/28/2014			

RE-WORK AS PER ECN14-516 TO REV. C
DELIVERY DATE TBA FOR ITEM D4822-1 X 10 PCS

Line Total: \$1,380.00

4	114009	D4822-2 MOD UPPER DEFLECTOR	3/14/2014	1.00	\$420.00	\$420.00
			Yes 3/14/2014			

RE-WORK AS PER ECN14-516 TO REV. C

114009			3/28/2014	10.00	\$96.00	\$960.00
			3/28/2014			

RE-WORK AS PER ECN14-516 TO REV. C
DELIVERY DATE TBA FOR ITEM D4822-2 X 10 PCS

Line Total: \$1,380.00

Note:

3/3/2014



Packing Slip 36727

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

S
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1000 Wellington Street
Kingston, ON K7P 1N3

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 4R6

INVOICE DATE	YOUR ORDER NO. <i>PJ 23205</i>	DATE ORDERED <i>03/03/14</i>	SHIPPED VIA <i>Best way</i>
CUSTOMER CODE	PROV. LIC. NO.	Extra <input type="checkbox"/> Exempt <input type="checkbox"/>	TERMS

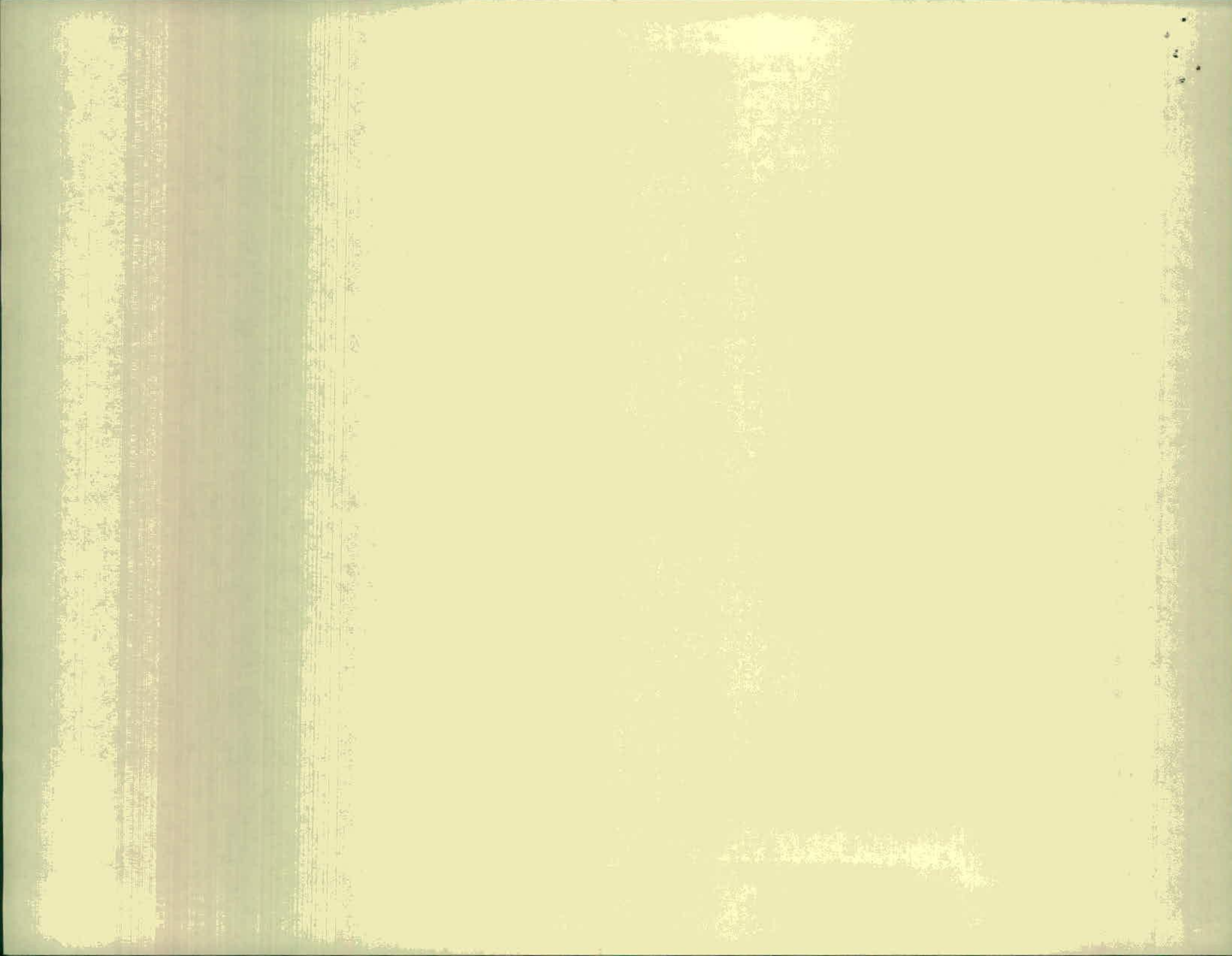
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
0	1	1	modify windshield deflector (add holes) as per drawing ECN104-516 to Rev. B DIP 1-1 Part number: 114007		
0	1	1	modify upper windshield deflector (add holes) as per drawing ECN104-516 to Rev. C DIP 1-1 (Left Hand) Part number: 114008		
0	1	1	modify upper windshield deflector (add holes) as per drawing ECN104-516 to Rev. C DIP 1-2 (Right Hand) Part number: 114009		
<p>Required by: March 14, 2014</p> <p>RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order.</p> <p>Inspection Supervisor <i>[Signature]</i> WMP 03 <i>MARCH 5/14</i></p>					
				G.S.T.	
				P.S.T.	

ORDER: COMPLETE ☐ PARTIAL ☐

TOTAL

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION





600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: March 5, 2014		
	P.O.# PO23205		
	WEJAY JOB# 36727		
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4821-1 'Windshield Deflector' Part number: 114007	1	Holes machined in existing part complete per drawing req'ts.	D4821 / rev. B
D4822-1 'Upper Deflector, LH' Part number: 114008	1	Holes machined in existing part complete per drawing req'ts.	D4822 / rev. C
D4822-2 'Upper Deflector, RH' Part number: 114009	1	Holes machined in existing part complete per drawing req'ts.	D4822 / rev. C
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith

Authorized Q.A. Signatory

